

Work Order ID 68185

Thursday, April 07, 2011 4:12:35 PM



Page 1

Item ID: D3913-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 4/7/2011 Start Qty: 3.00



Cust Item ID:


Required Date: 4/8/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 11-04-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3913

A

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D3913
2- remove identification marks and deburr

SAD 11-04-13

(3)

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

11-004-13

120

Identify as per dwg & Stock Location: Q1A

0.00



Packaging

Memo

0.00

Packaging

SAD 11-04-13

(3)

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Thursday, April 07, 2011 4:12:35 PM

Page 2

Item ID: D3913-3

Accept

Revision ID:

Item Name: Rib

Start Date: 4/7/2011 Start Qty: 3.00

Required Date: 4/8/2011 Req'd Qty: 3.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/18
ME
11-04-18

Picklist Print

Thursday, April 07, 2011 4:12:41 PM

Page 1

Work Order ID: 68185

Parent Item: D3913-3

Parent Item Name: Rib



Start Date: 4/7/2011

Required Date: 4/8/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
11.02.04 chg qc5 to 6 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TS0.750W.049

Purchased

No

100

f

326.9645

8

25.26316



304 SQ Tube .75x.75x.049W



SAD 11-03-13

Location

Loc Qty

Loc Code

MAT018

26.9645

117029

26.9645

MAT034

300

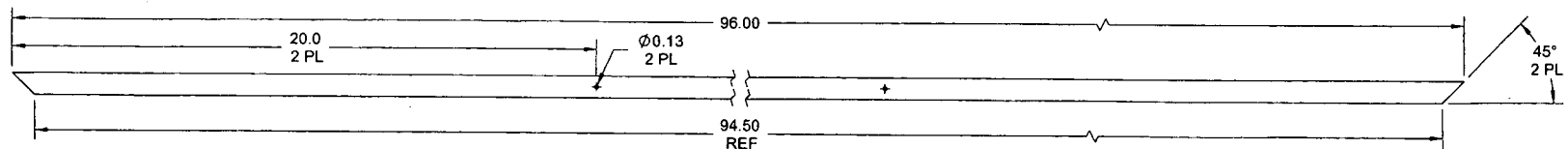
117337

300

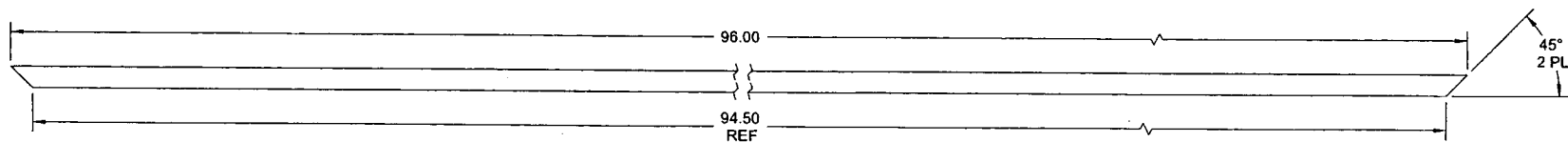
25.2672

1.000 End Bar Scrap

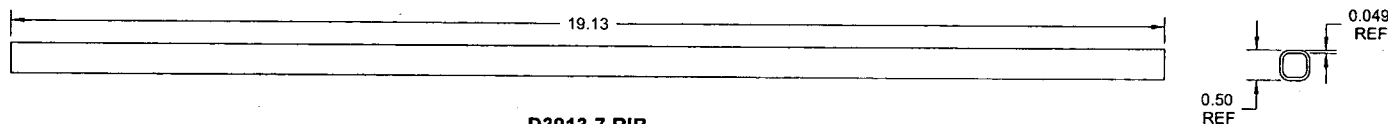
26.2672



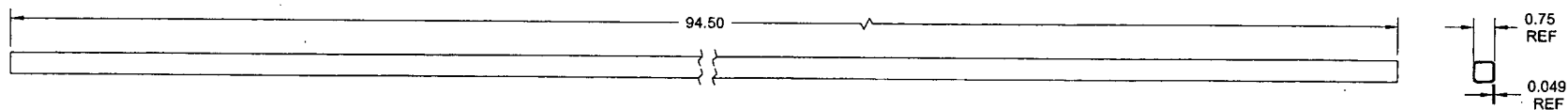
D3913-1 RIB



D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB

NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *68135*

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

11-047

